

Work Order ID 124521

124521

September-11-14 12:08:16 PM

Page 1

Item ID: D2535 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spring
 Start Date: 9/10/14 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-09-18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2535	Rev A								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 25825 Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring
CX 14/09/18 50

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached
14/9/22 [Signature] (50)

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control Check dims to dwg
50 DAS 38 9-89 14-9-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location	0.00							
130									
Packaging	Memo	0.00				50x		DAS 26 9-89	SEP 23 2014
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 14-09-24

214-923

DQA: _____ Date: _____



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Picklist Print

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Page 1

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Parent Item: D2535

D2535

Parent Item Name: Spring


Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A99.04.19New Issue (From hand written IPP)DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2535P *D2535P* Spring		Purchased	No			100	Each	0.0000	1	50		14/9/22 50	

DQA: _____ Date: _____



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Process									
Supplier									
Training									
Transport									
Unapproved									

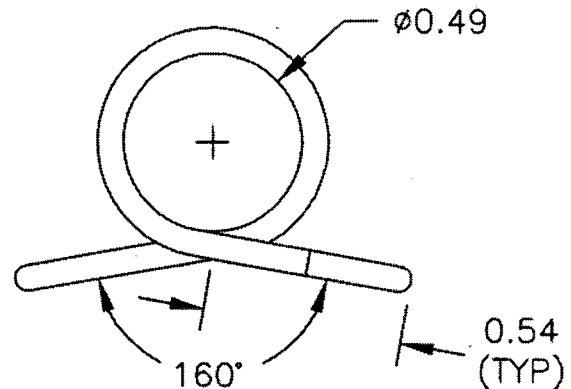
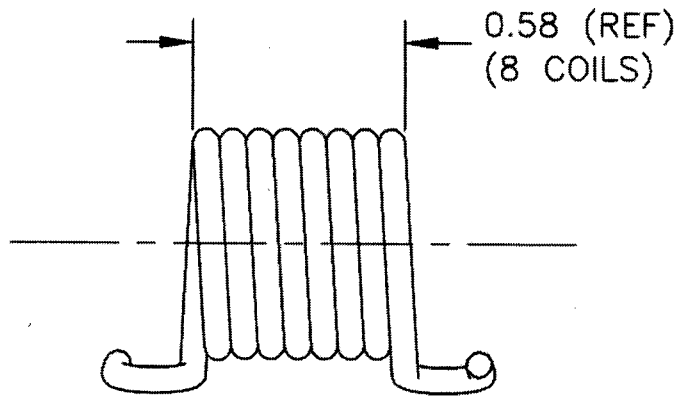
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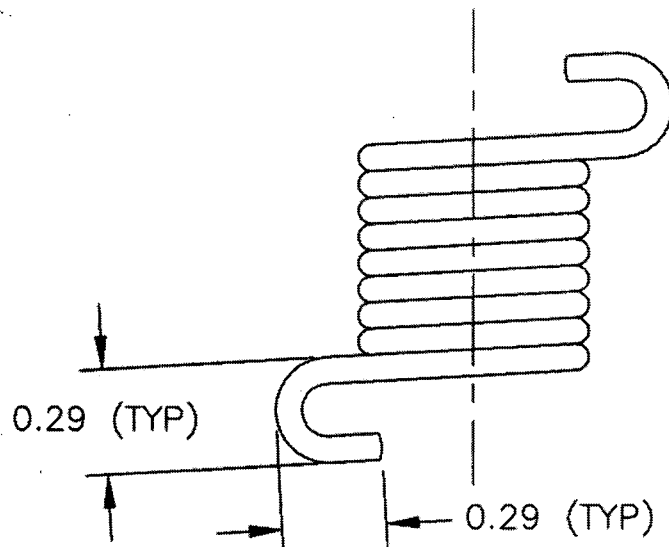


DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124521 MJS
14-09-18



SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25825

Purchase Order Date 9/18/2014

PO Print Date 9/18/2014

Page Number 1 of 2

Order From :

VC-VIC002

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone

866 230 5312

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2535P AS PER DWG D2535 REV. A B124521	Spring	9/29/2014 Yes 9/29/2014		50.00 Each	\$4.56	\$228.00
Line Total:							\$228.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	9/29/2014 No 9/29/2014		1.00	\$0.00	\$0.00
Procurement Quality Clauses A005 RIGHT OF ENTRY A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE) A016 PERSONNEL QUALIFICATION A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS							

Note:

9/18/2014

PACKING SLIP 30805

VICTORY SPRING

convenient, consistent, correct.

#2-6104 - 82 Ave
Edmonton, AB T6B 0E7
1-780-442-4020
1-800-466-8000

BILL TO:
Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

SHIP TO:
Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

DATE		ORDER No.		SHIP VIA	
Sep 18, 2014		PO25825		Pallet	
QUANTITY	DESCRIPTION			UNIT	AMOUNT
50	VIC 1533 D2535P Spring - Torsion				

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd.	DATE: 9/18/2014
PART/DRAWING #: D2535P VIC 1533	PO # 25825
DESCR: Torsion Spring	QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS302	yes	
Material diameter	0.07	0.072	
Coil I.D.	0.490	.492"	
Coil O.D.		.636"	
Number of Coils	8 ref	7.9	
Overall Length		1.12	
End Type	per dwg	yes	
Helix	RHW	RHW	

COMMENTS

Mill Certificate attached: no
Material Heat Number: 35791

Inspected by: *Jeremy Burrows*